

Date: Wednesday, 06/08/2008 10:35:48 AM  
 User: Melanie Fauteux

## Process Sheet

ASAP

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 412 SKI WEARPLATE  
 Job Number : 41010  
 Estimate Number : 13543  
 P.O. Number :  
 This Issue : 06/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D3796043  
 First Issue : / / Type : R & D SM/MED FAB Drawing Number : D3796 REV.A PREL  
 Previous Run :  
 Written By :  
 Checked & Approved By : CMF 08-08-06 Project Number : N/A  
 Comment : Est Rev:A 08-08-05 new issue. DD verified by:ec Drawing Revision : PRELIM  
 Material :  
 Due Date : 06/08/2008 Qty: 2 Um: Each



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304S16GA 304/316 Sheet .063



Comment: Qty.: 2.0076 sf(s)/Unit Total: 4.0152 sf(s)

NEOPRENE SHEET 0.063

batch: 108724

B 8-8-6



2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3796

Dwg Rev: PRE LProg Rev: PRE L

2-Deburr if necessary

B 8-8-6

B 8-8-6

3



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-8-6



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK



S08/08/06 43

5.0 D30093 Cup



Comment: Qty.: 12.0000 Each(s)/Unit Total: 24.0000 Each(s)

Cup

batch: B37489 → 12 B 40613 → 4 B 41075-2 → 8

080811

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Drawing Name: 412 SKI WEARPLATE

Job Number: 41010

Part Number: D3796043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



PTO

Comment: LARGE FABRICATION RESOURCE 1

Weld hardcoat and cups as per dwg D3796

Pl 08-08-11 / 12 8-8-11 (X2)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11-08-11 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

11-08-11 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 08/08/11 AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

powdercoat grey \_\_\_\_\_

QC3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08-08-11	6.0	took 1 piece to FABRICATE JIG DT 9037	pl	08-08-11	1	06-08-18	08-08-18	

Part No: D3796-043 PAR #:            Fault Category: LGE FAB NCR: ~~Yes~~ No DQA:    Date: 08-08-21  
D412-777 "Process" QA: N/C Closed:    Date: 08-08-22

NCR: <u>41010</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-08-18	6.0	Parts were warping during welding, causing them not to fit during installation. R.C. No jig to hold them flat.	<u>  </u>	- Made DT 9040 - Scrapped last tray Qty 2 - Replace - T.P.P updated with DT#	<u>  </u> 08-08-18	<u>  </u> 08-08-18	<u>  </u> 08-08-18	<u>  </u> 08-08-18

NOTE: Date & initial all entries

